



Dart Aerospace Ltd.  
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Canada

Tel (613) 632-5200

*STK*

**D2666-1**

**Job Sheet 172163**



**Part No:** D2666-1

**Job Qty:** 4 ea

**Part Name:** Saddle, LH, Fwd, Aft, In



**Part Weight:** 0 lbs

**Status:** Scheduled

**Priority:** Medium

**Job Created:** 2/13/18

**Job Tracking No:**

**Due Date:** 3/16/18

**Created By:** Michelle Gagnon-Donovan

**Type:** Stock

**Description:**

**Note:** DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D 07-03-19 JLM

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation              | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off     |
|-------|------------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|--------------|
|       |                        |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |              |
| 90    | Start up Operation     | 4 Ea  | 3/15/18    | 0.00     | 0.00      |         | Start Up Machining-1  |           | SBL 18/05/14 |
| 100   | CNC Vertical Machining | 4 pcs | 3/15/18    | 1.54     | 5.71      |         | HAAS1-2               |           | SBL 18/05/14 |
| 110   | Mill Conv              | 4 pcs | 3/15/18    | 0.00     | 4.49      |         | Mill Conv 1           |           | SBL 18/05/14 |
| 120   | QC                     | 4 pcs | 3/15/18    | 0.00     | 0.00      |         | QC2 Machining-1       |           | SBL 18/05/14 |
| 130   | QC                     | 4 pcs | 3/15/18    | 0.00     | 0.00      |         | QC8 Machining-1       |           | SBL 18/05/14 |
| 140   | HandFinish             | 4 pcs | 3/15/18    | 0.00     | 0.21      |         | HandFinish1           |           | SBL 18-05-17 |
| 150   | Powdercoat             | 4 pcs | 3/16/18    | 0.00     | 0.18      |         | Powdercoat1           |           | SBL 18-05-17 |
| 160   | QC                     | 4 pcs | 3/16/18    | 0.00     | 0.00      |         | QC3                   | 68-6      | SBL 18-05-17 |
| 170   | Packaging              | 4 pcs | 3/16/18    | 0.00     | 0.00      |         | Packaging3-1          | 9         | SBL 18-05-17 |
| 180   | QC21-SA                | 4 Ea  | 3/16/18    | 0.00     | 0.00      |         | QC21                  | 9         | SBL 18-05-17 |

Part Op 100 - Program batch number.

Descriptions: 110 - Machine Keyway and inspect per attached dimension sheet.

150 - START TIME:

*11:05 OUT: 300 FINISH 11:35 M188839*

### Job BOM

| Part / Item | Component Name | Quantity    | Operation             | Container |
|-------------|----------------|-------------|-----------------------|-----------|
| D6101-001   | Saddle Billet  | 4 Ea (1 ea) | 90-Start up Operation |           |

*5067879 → 5070979*

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | D6101-001      | 4        | 49        | 0         |

### Part Specifications

Specifications could not be found.

Plex 2/13/18 10:48 AM Dart.Gagnon.Michelle



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Container No: S070980



Part: D2666-1

Job No: 172163

Serial No/Batch: S070980

Revision:

Inspector:

Date: 05/14/18



|                                                                    |  |  |  |                             |  |
|--------------------------------------------------------------------|--|--|--|-----------------------------|--|
| <b>DART AEROSPACE LTD</b>                                          |  |  |  | <b>Work Order:</b> 172 163  |  |
| <b>Description:</b> 206 Saddle, Inboard, Left side                 |  |  |  | <b>Part Number:</b> D2666-1 |  |
| <b>Inspection Dwg:</b> D2666 <b>Rev:</b> D <b>DSK:</b> <b>Rev:</b> |  |  |  | <b>Page 1 of 1</b>          |  |

### FIRST ARTICLE INSPECTION DIMENSION SHEET

| Dim | Min   | Max   | Go/No Go Gauge | Record Actual Dimensions |       |       |       |   |
|-----|-------|-------|----------------|--------------------------|-------|-------|-------|---|
|     |       |       |                | 1                        | 2     | 3     | 4     | 5 |
| A   | 0.100 | 0.140 |                | .123                     | .123  | .122  | .123  |   |
| B   | 0.100 | 0.140 |                | .118                     | .118  | .118  | .118  |   |
| C   | 2.470 | 2.510 |                | 2.497                    | 2.495 | 2.495 | 2.495 |   |
| D   | 0.100 | 0.180 |                | .135                     | .135  | .136  | .136  |   |
| E   | 0.210 | 0.230 |                | .220                     | .219  | .219  | .219  |   |
| F   | 1.313 | 1.343 |                | 1.322                    | 1.322 | 1.322 | 1.322 |   |
| G   | 0.240 | 0.260 |                | .250                     | .249  | .249  | .250  |   |
| H   | 0.615 | 0.685 |                | .650                     | .650  | .650  | .650  |   |
| I   | 1.125 | 1.145 |                | 1.135                    | 1.135 | 1.135 | 1.135 |   |
| J   | 0.990 | 1.010 |                | 1.004                    | 1.005 | 1.004 | 1.004 |   |
| K   | 0.235 | 0.240 |                | .238                     | .238  | .238  | .238  |   |
| L   | 0.510 | 0.515 |                | .510                     | .510  | .510  | .510  |   |
| M   | 0.100 | 0.120 |                | .110                     | .110  | .110  | .110  |   |
| N   | 1.565 | 1.585 |                | 1.575                    | 1.575 | 1.575 | 1.575 |   |
| O   | 5.990 | 6.010 |                | 6.000                    | 6.000 | 6.000 | 6.000 |   |
| P   | 1.245 | 1.255 |                | 1.250                    | 1.250 | 1.250 | 1.250 |   |
| Q   | 2.495 | 2.505 |                | 2.500                    | 2.500 | 2.500 | 2.500 |   |
| R   | 0.490 | 0.510 |                | .498                     | .500  | .500  | .500  |   |
| S   | 0.312 | 0.318 |                | .313                     | .313  | .313  | .313  |   |
| T   | 2.495 | 2.505 |                | 2.500                    | 2.500 | 2.500 | 2.500 |   |
| U   | 1.357 | 1.367 |                | 1.362                    | 1.362 | 1.362 | 1.362 |   |
| V   | 0.315 | 0.322 |                | .316                     | .316  | .316  | .316  |   |
| W   | 0.540 | 0.560 |                | .550                     | .548  | .548  | .550  |   |
| X   | 1.674 | 1.684 |                | 1.679                    | 1.679 | 1.679 | 1.679 |   |
| Y   | 0.256 | 0.262 |                | .257                     | .257  | .257  | .257  |   |
| Z   | 0.178 | 0.198 |                | .188                     | .188  | .188  | .188  |   |
| AA  |       |       |                |                          |       |       |       |   |
| AB  |       |       |                |                          |       |       |       |   |
| AC  |       |       |                |                          |       |       |       |   |
| AD  |       |       |                |                          |       |       |       |   |
| AE  |       |       |                |                          |       |       |       |   |

Accept/Reject

|                                |                       |
|--------------------------------|-----------------------|
| <b>Measured by:</b> SBL/amy    | <b>Date:</b> 18/05/14 |
| <b>Audited by:</b> [Signature] | <b>Date:</b> 18/05/16 |
| <b>Prototype Approval:</b>     | <b>Date:</b>          |

| Rev | Date     | Change                                                 | Revised by | Approved |
|-----|----------|--------------------------------------------------------|------------|----------|
| A   |          | New Issue                                              | RF         |          |
| B   | 99.04.19 | Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A      | RF         |          |
| C   | 99.11.10 | Added Dim. R-T                                         | RF         |          |
| D   | 02.12.12 | Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B | KJ/RF      |          |
| E   | 06.06.30 | Dimension revised per drawing revision C               | KJ/JLM     |          |
| F   | 06.09.19 | Reference to DT8888 added to Dim N                     | KJ/EC      |          |
| G   | 07.03.21 | Revised per drawing revision D                         | KJ/JLM     |          |
| H   | 12.03.08 | Dimension S and Y revised                              | KJ         | M        |